

# Work Order ID 52535

September 29, 2009 12:54:15 PM



Page 1

Item ID: D3847-047 *GY*  
 Revision ID: B  
 Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/30/2009 Start Qty: 2.00  
 Required Date: 10/12/2009 Req'd Qty: 2.00



Cust Item ID:  
 Customer:

Reference:

Approvals: Process Plan: *VMF* Date: *09-09-29* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3847	B								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3847 Dwg Rev: <i>8</i> Prog Rev: <i>8</i> 2-Deburr if necessary	0.00							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

*IB 9-9-30*

*IB 9-9-30*

*(4)*

**Work Order ID 52535**

September 29, 2009 12:54:15 PM



Page 2

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Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

275 09/07/30



QC

Memo

0.00

(24)

/

Quality Control

130

Memo

0.00

88 09/10/05



Brake NC

Memo

0.00

4

/

Brake NC

form as per dwg D3847

140

QC5- Inspect part completeness to step on W/O

0.00

275 09/10/05



QC

Memo

0.00

(24)

/

Quality Control

**Work Order ID 52535**

September 29, 2009 12:54:15 PM



Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 109091. START 1:05 Memo OVEN TEMP. 320° FINISH 1:35</i>	0.00 0.00	<i>BR 09-10-6</i>			<i>(14)</i>			
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>ML 09/10/07</i>			<i>(X4)</i>			
170  Small Fab Small Fab	 Memo 1- Bond gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg D3847 BATCH: <i>M 111 428</i>	0.00 0.00				<i>4</i>	<i>0</i>		<i>SB 09/10/07</i>

**Work Order ID 52535**

September 29, 2009 12:54:15 PM



Page 4

Item ID: D3847-047  
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Setup Start



Stop



Start Date: 09/30/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 807/10/07



190



Packaging

Packaging

Identify as per dwg & Stock Location: MP

0.00

Memo

0.00

9/10/8

4050

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/10/13

MF

09-10-08

# Picklist Print

September 29, 2009 12:54:14 PM

Page 1

Work Order ID: 52535

Parent Item: D3847-047RevB

Parent Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/30/2009

Required Date: 10/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-7RevB GASKET		Manufactured	No				Each	4.0000	2.0000			

BS1832 09/10/09 (4)

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

4

51832

4

M304S18GA

Purchased

No

sf

154.6396

2.6526

5.3052

18 9-9-30

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

154.6396053

108156

0.98526316

111743

23.7174

112178

129.936942

112178

304/316 .050 Sheet

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52535
<b>Description:</b> ACT WEAR PLATE ASSY STD GEAR		<b>Part Number:</b> D3847-047
<b>Inspection Dwg:</b> D3847-7 <b>Rev:</b> B		<b>Page 1 of 1</b>

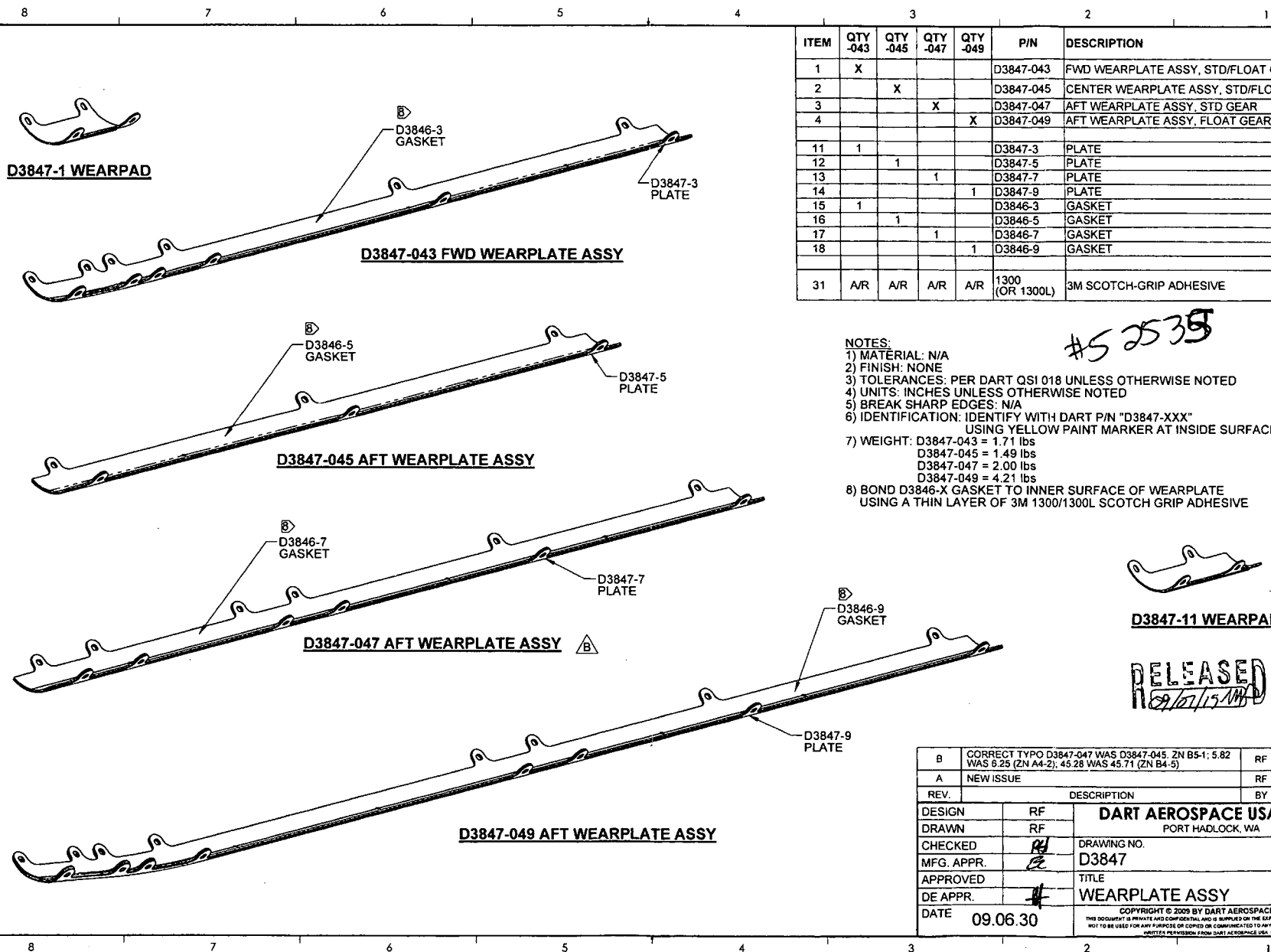
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.192	*			
300 X 305	± .010	305 X 310	*			
2.45	± .030	2.400	X			
4.13	± .030	4.123	X			
1.69	± .030	1.691	X			
3.280	± .010	3.276	X			
.75	± .030	.749	X			
8.96	± .030	8.956	X			
10.000	± .010	10.000	X			
20.000	± .010	20.000	X			
30.000	± .010	30.000	X			
45.28	± .030	45.28	X			
12.740	± .010	12.740	X			
25.481	± .010	25.481	X			
28.981	± .010	28.981	X			
38.148	± .010	38.148	X			
41.648	± .010	41.648	X			
.050	± .010	.048	X			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 9-9-30	<b>Date:</b> 09/09/30	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE  
 7) WEIGHT: D3847-043 = 1.71 lbs  
 D3847-045 = 1.49 lbs  
 D3847-047 = 2.00 lbs  
 D3847-049 = 4.21 lbs  
 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

#5 2535



D3847-11 WEARPAD

RELEASED  
 09/07/15

B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 9.25 (ZN A4-2); 43.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

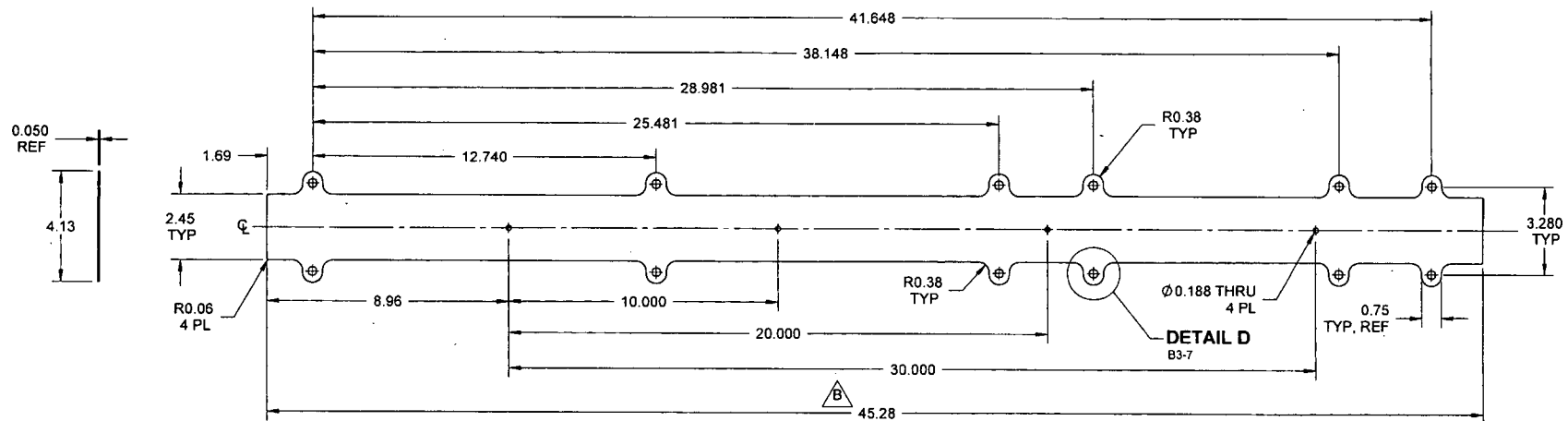
DART AEROSPACE USA, INC.  
 PORT HADLOCK, WA

DRAWING NO. D3847  
 REV. B  
 SHEET 1 OF 7  
 TITLE WEARPLATE ASSY  
 SCALE NTS

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**D3847-7 PLATE**  
MADE FROM D3847-7F FLAT PATTERN

#52535



**D3847-7F FLAT PATTERN**

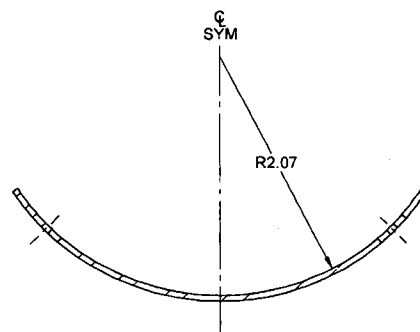
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.70 lbs

RELEASED  
06/19/14

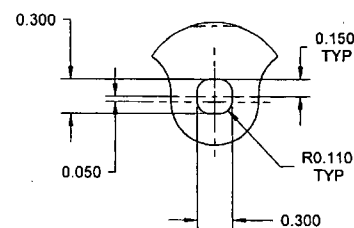
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	CE	D3847	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.	#	WEARPLATE ASSY	NTS
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**SECTION C-C**  
SCALE 4X

D4-3  
D4-4  
D3-5  
D3-6



**DETAIL D**  
TYP. SCALE 4X

B5-3  
B6-4  
B3-5  
B5-6

# 52538

RELEASED  
09/07/15 MTD

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 7 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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